

Date: Monday, 22/12/2008 2:08:24 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B BASKET LID
 Job Number : 44222A
 Estimate Number : 11280
 P.O. Number :
 This Issue : 22/12/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 40843A
 Written By :
 Checked & Approved By : UMF 08-12-23
 Comment : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K
 J
 Est Rev:l 08-09-09 revF as per dwg (ecn 08-522) DD verified
 by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

✓ 1.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 30.2568 f(s)/Unit Total : 30.2568 f(s)

3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

Batch: M110 335

SAD 08-01-16

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

SAD 09-01-16

3.0 D22321 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch
 2 D2232-1 HINGE

B39454 → 2x

SAD 09/01/20

4.0 D2329 Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:



Qty Part Number Description Batch
 1 D2329 Label Plate

B35689 → 1x

SAD 09/01/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 44222A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23271

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-1 Bushing B 410390

SY 09/01/20

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Chancel B 43800

SY 09/01/20

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 18.9000 sf(s)/Unit Total: 18.9000 sf(s)

Pick:

Qty Part Number Description Batch

18 sf M304EX0.75-16F Expanded Metal M110292

SAD 09-01-20

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig SY

Deburr as required

A/R SS ROD Batch: M108775

SY 09/01/20 (12)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-26 (1)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/26 (10)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 44222A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



PRESSURE WASH BR 09-01-28



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 109996

(P)

START TIME:

8:15

OVEN TEMPERATURE:

400°

FINISH TIME:

8:45

FL 09/01/28

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



98



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-28

87

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

44222 n

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/2008

Job Completion



u 9-11-30

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D2330-041	BASKET ASSEMBLY
	X	D2330-043	LID ASSEMBLY
1		D2012-107	CLEVIS
	2	D2232-1	HINGE
2		D2232-3	HINGE
4		D2235-1	RIB
2		D2253-1	LUG
2		D2254	GUSSET
	1	D2327-1	BUSHING
1		D2327-3	BUSHING
	1	D2329	LABEL PLATE
2		D2330-1	FRAME
2	2	D2330-3	FRAME
1		D2330-5	FRAME
1		D2330-7	FRAME
1	2	D2330-9	FRAME
	2	D2330-11	FRAME
	2	D2330-13	FRAME
	1	D2330-15	FRAME
4	2	D2581	MOUNTING CHANNEL

REFERENCE ONLY
44222A

RELEASED
08-09-11


NOTES:
 FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
 REF. DART SPEC M304TS0.750W.065
 MESH MATERIAL: 3/4-16F EXPANDED SS
 REF DART SPEC M304EX0.75-16F
 FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: N/A
 IDENTIFICATION: N/A
 WEIGHT: N/A
 WELD PER DART QSI 004

F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1, D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2330 TITLE BASKET ASSEMBLY (206B) DATE 08.08.11	
DRAWN	AJS		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	JB		
DE APPR.	JB	REV. F SHEET 1 OF 6 SCALE NTS	
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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

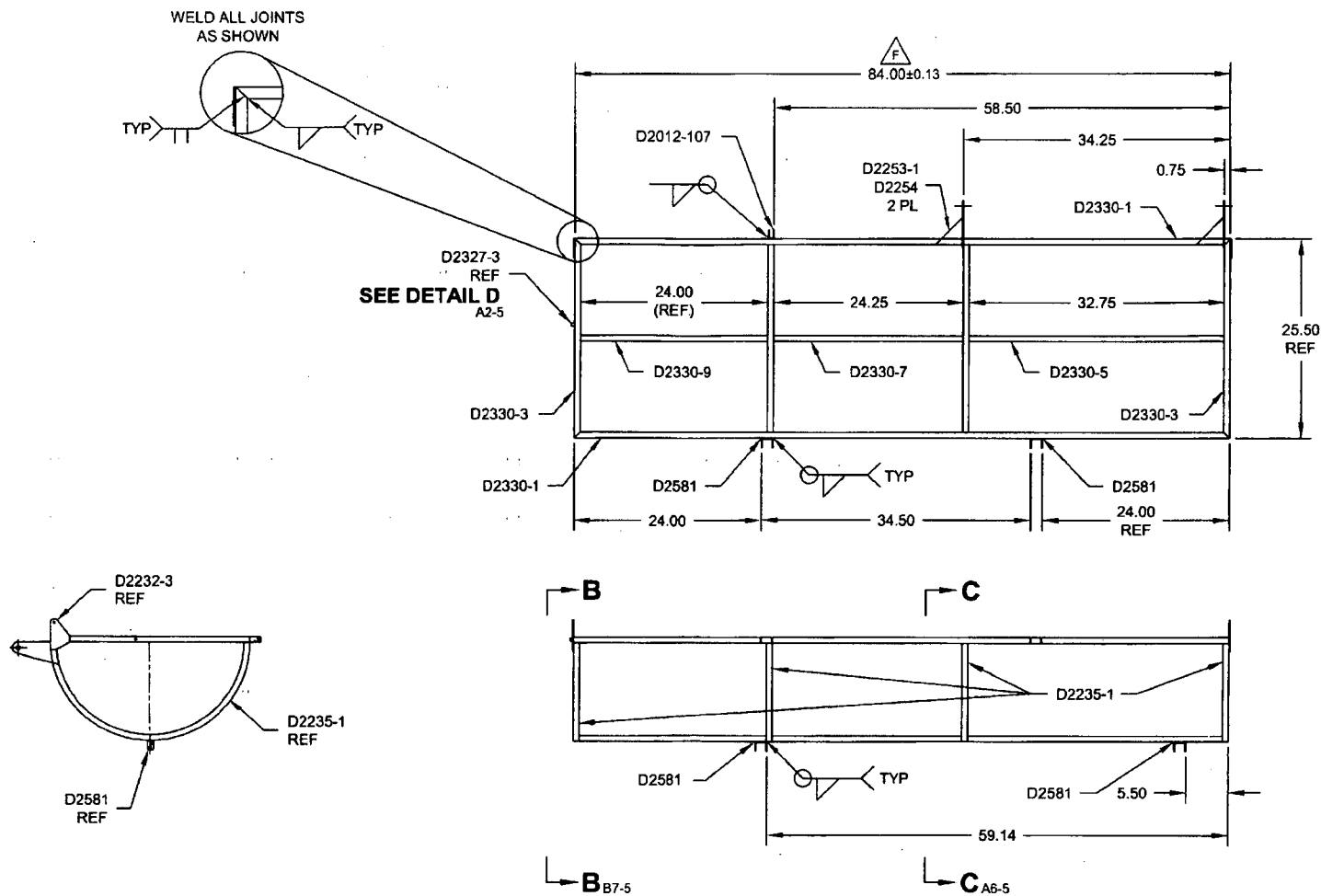
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RELEASED
08-09-05/10

D2330-041 BASE FRAME ASSEMBLY

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2330	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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REFERENCE ONLY
44222A

BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

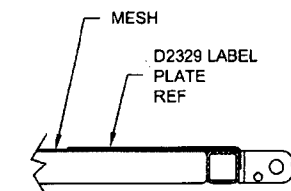
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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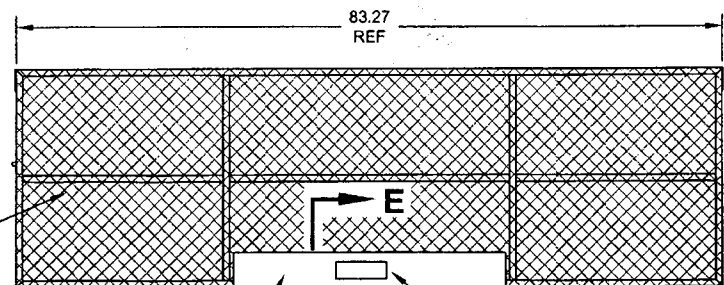
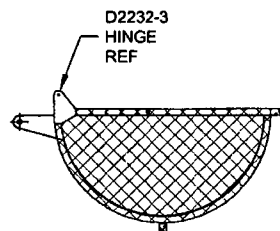
NOTE: Date & initial all entries



SECTION E-E C3-4
VIEW ROTATED 90° CCW



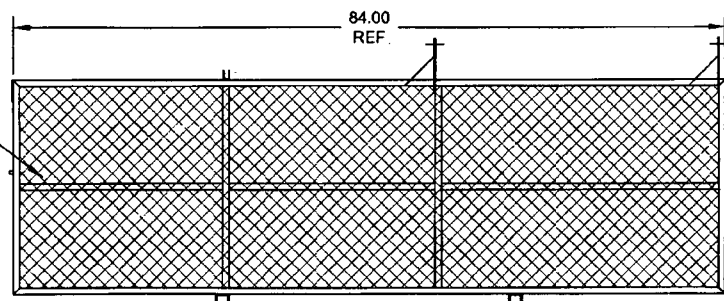
TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



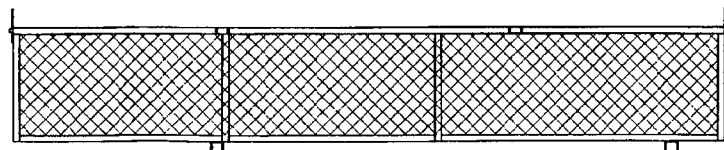
D2329 LABEL PLATE
CENTER ON THE
BASKET LID

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

D2330-043 LID ASSEMBLY







D2330-041 BASE ASSEMBLY



RELEASED
08-05-11

- ASSEMBLY NOTES:**
- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELD PER DART QSI 004

REFERENCE ONLY
44222A

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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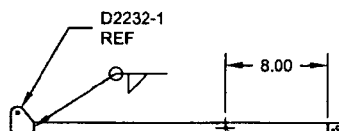
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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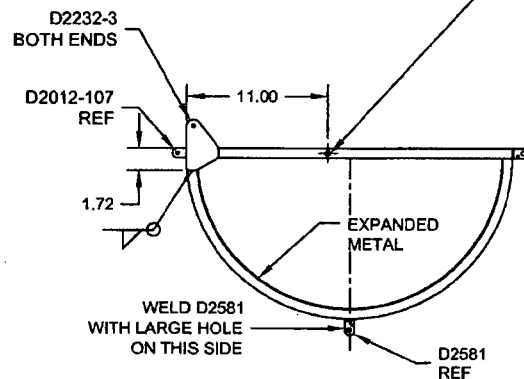
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

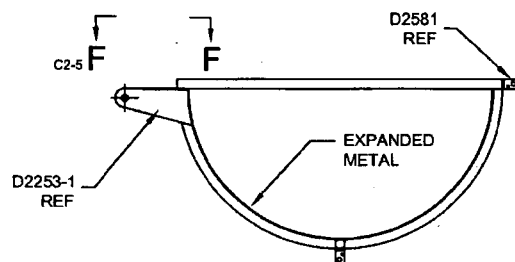


VIEW A-A A6-2

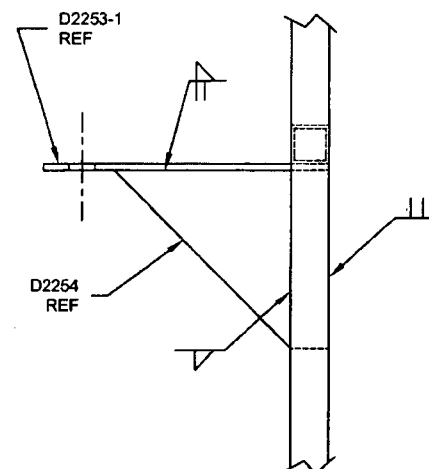
DRILL 3/8 HOLE AND
INSTALL D2327-1/3
SEE DETAIL D A2-5



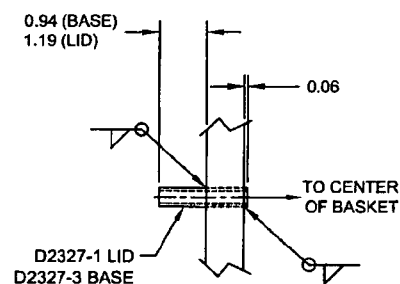
VIEW B-B A5-3



VIEW C-C A3-3



VIEW F-F B8-5
SCALE 4X



DETAIL D
SPACER INSTALLATION
SCALE 4X

RELEASED
08/08/11

REFERENCE ONLY
#44222A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2330	SHEET 5 OF 6
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8 7 6 5 4 3 2 1

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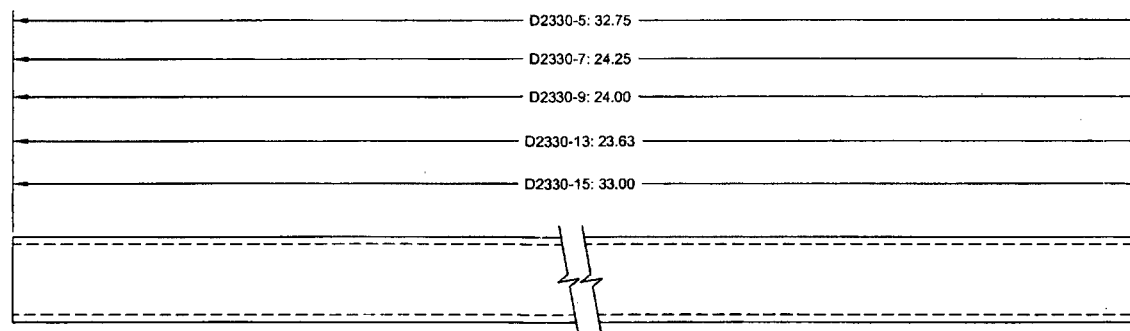
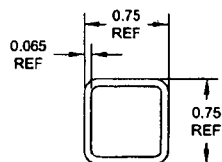
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

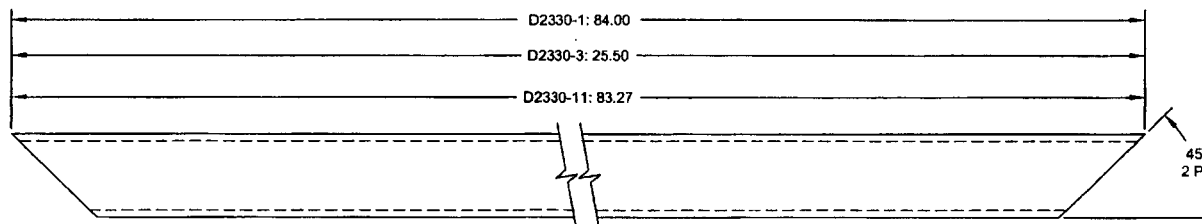
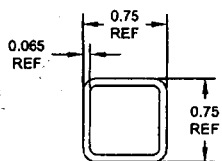
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8 7 6 5 4 3 2 1



D2330-5 FRAME
D2330-7 FRAME
D2330-9 FRAME
D2330-11 FRAME
D2330-13 FRAME
D2330-15 FRAME



D2330-1 FRAME
D2330-3 FRAME
D2330-11 FRAME

RELEASED
68-09-05 110

- NOTES:**
1) FRAME MATERIAL: SEE SHEET 1
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

REFERENCE ONLY
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8 7 6 5 4 3 2 1

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